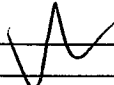
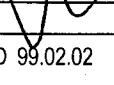


Date: Tuesday, 27/03/2007 12:43:14 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 205 SKIDTUBE "I" BEAM  
 Job Number : 31517  
 Estimate Number : 10346  
 P.O. Number : N/A Part Number : D2596  
 This Issue : 27/03/2007 S.O. No. : N/A Drawing Number : D2596 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : C  
 Previous Run : 31213 Material : N/A  
 Due Date : 03/04/2007 Qty: 20 Um: Each  
 Written By :   
 Checked & Approved By :   
 Comment : Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D  
 M

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |           |                         |
|-----|-----------|-------------------------|
| 1.0 | D25003100 | Ext'n - "I" Beam Web 4" |
|-----|-----------|-------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)  
 Extrusion "I" Beam Web 4"

Pick;

| Qty | Part Number | Description | Batch  |
|-----|-------------|-------------|--------|
| 1   | D2500-3-100 | Extrusion   | B35751 |

Jh 7-3-28

|     |                |                         |
|-----|----------------|-------------------------|
| 2.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

JD 7-3-28

|     |                 |                            |
|-----|-----------------|----------------------------|
| 3.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1

JD 7-3-28

|     |     |                              |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

JD 7-3-29

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: H Date: 07/03/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 27/03/2007 12:43:14 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 31517

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



(20)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

JD 7-3-29

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/30

Job Completion:



u 07-03-30

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

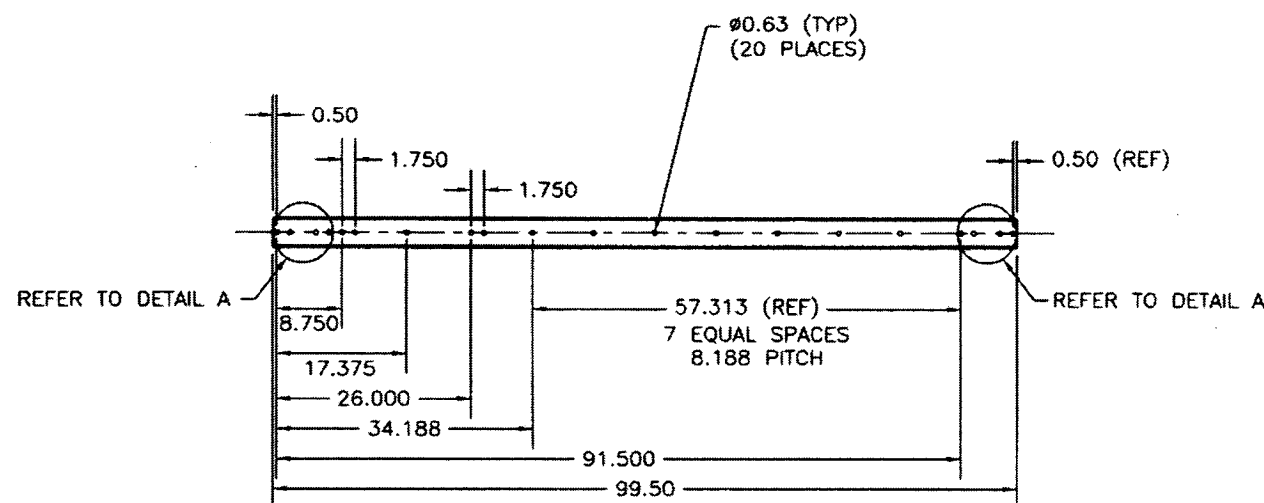
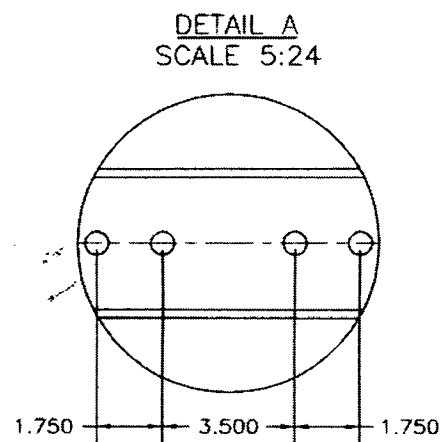
NOTE: Date & initial all entries

**DART**



RELEASED  
98 09 17 05

|          |          |   |              |
|----------|----------|---|--------------|
| DESIGN   | DRAWN BY | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA | REV. C       |
| CHECKED  | APPROVED | DRAWING NO. D2596                                 | SHEET 1 OF 1 |
| DATE     | TITLE    | 205 WEB   | SCALE        |
| 98.09.14 |          |   | 1:24         |
| A        | 96.09.16 | NEW ISSUE   |              |
| B        | 97.07.23 | Ø0.63 HOLE WAS Ø0.56                              |              |
| C        | 98.09.14 | INCORPORATED DEO 9097                             |              |



W/O  
3/15/7

MANUFACTURED FROM D2500-3 EXTRUSION  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

